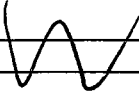
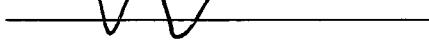


Date: Monday, 04/05/2009 3:39:38 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D350-748-201UP
Job Number : 47731	
Estimate Number : 10804	
P.O. Number :	Part Number : D350748201
This Issue : 04/05/2009 S.O. No. :	Drawing Number : PAINT
Prsht Rev. : NC	Project Number :
First Issue : / / Type : CROSSTUBES	Drawing Revision :
Previous Run : 47730	Material :
Written By : 	Due Date : 11/05/2009 Qty: 1 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	SPRAY PAINTING	SPRAY PAINTING
-----	----------------	----------------



Comment: SPRAY PAINTING
 PULL FROM STOCK:

1 X D350-748-201UP B43518 CHG 001

DISASSEMBLE AND KEEP STK
 TO REASSEMBLE AFTER PAINT

SPRAY PAINT PER QSI005

ml 09.05.13

(1)

2.0	D350748201UP	Crosstube Installation, High Aft-UNPAINT
-----	--------------	--



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Crosstube Installation, High Fwd-UNPAINT

3.0	QC14	INSPECT SPRAY PAINT
-----	------	---------------------



Comment: INSPECT SPRAY PAINT

25 09.05.14

4.0	CROSSTUBES	CROSSTUBES RESOURCE 1
-----	------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

B:42437 — 2-Install Abrasion strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

ml 09.05.19 (1)

Date: Monday, 04/05/2009 3:39:38 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-748-201UP

Job Number: 47731

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/19 ①

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS
ENSURE ORIGINAL KIT WITH CROSSTUBE

** Ensure original label is removed from the kit: a new label is created & 09/05/20 ①*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE USING NEW B/N
NEW LABELS REQUIRED

09/05/20

2/5/20

*CHG 001
JUD 09-05-20 ①*

09/05/20 ①

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/20 ①

Job Completion



*mf
09-05-25*

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P N	D350-748-201 UP	CHG	CHG001		
DESC	Crosstube Aft High	STC	SH06-27		
LOT	B43518	STC	SR02359NY		
MODEL	AS350/355	STC			
MADE IN CANADA				D2729-1	

DART**RELEASED**

06.10.31

DESIGN 90	DRAWN BY 90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D350-748-241	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6018-125 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125
FINISHED LENGTH = 122.70±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

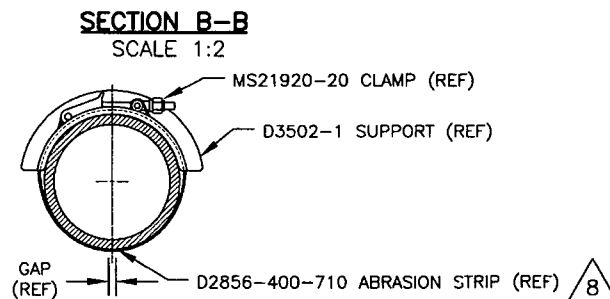
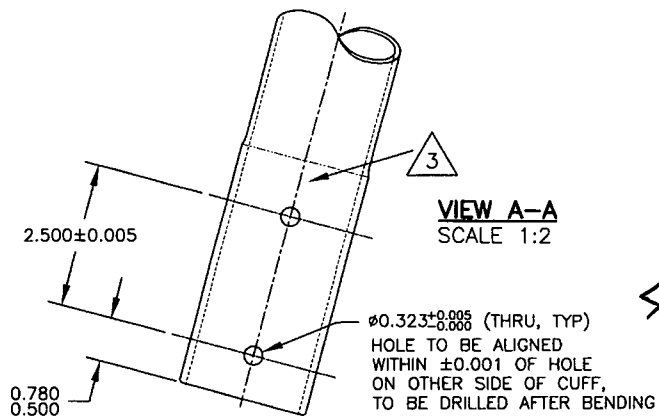
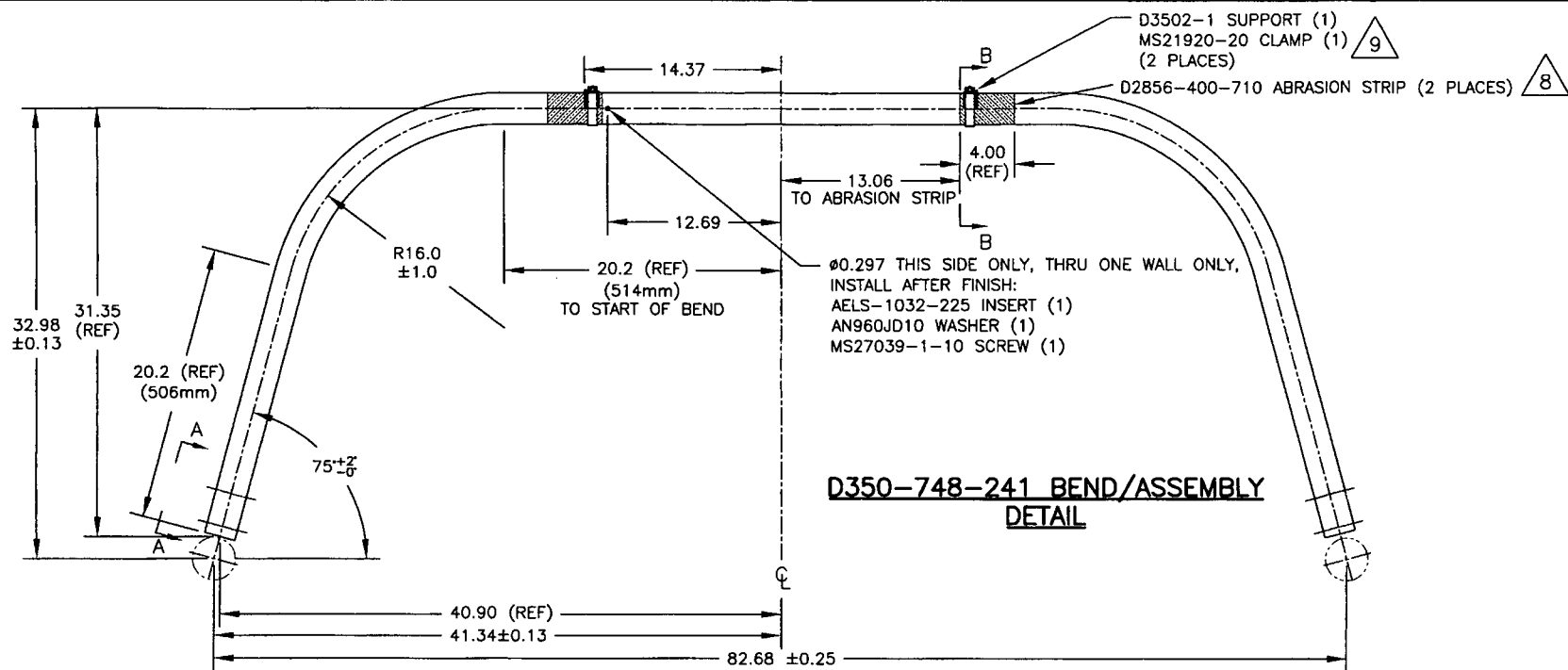
UNDER REVIEW09.02.05
PER PCR 309-001**UNDER REVIEW**

07.02.16

CUTTING PLATE
OK 07.10.22

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UNDER REVIEW

09.02.05

UNDER REVIEW

07.02.07

OK 12.10.22

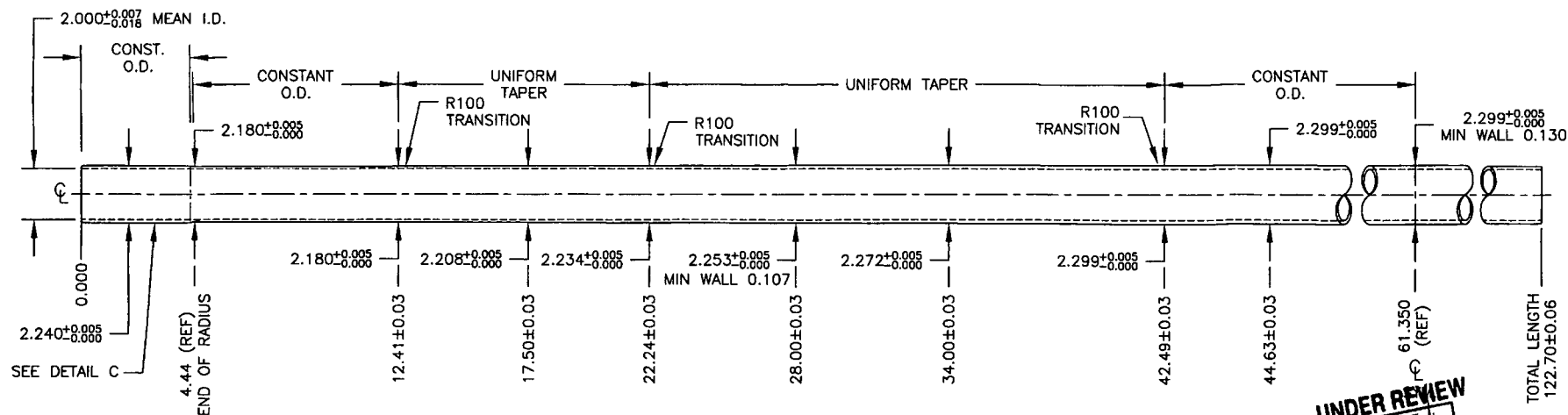
RELEASED

06.10.31

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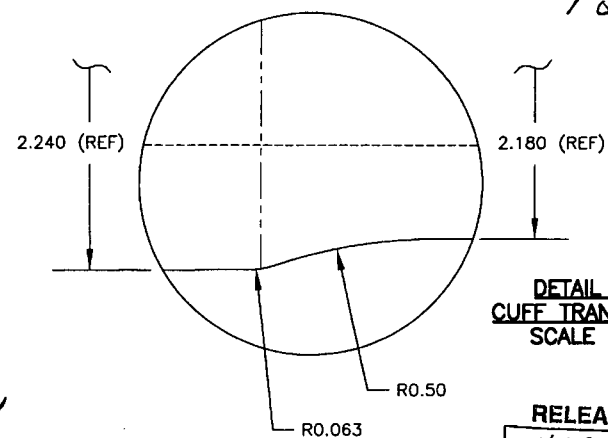
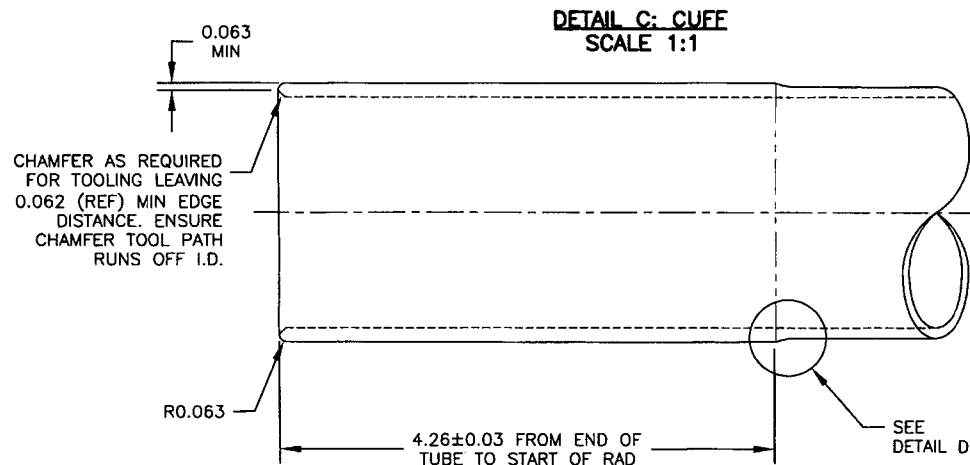
DESIGN 90	DRAWN BY 90	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D350-748-241	REV. 0 SHEET 2 OF 3
DATE 06.10.31	TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE 1:8	



D350-748-241 MACHINING DETAIL

UNDER REVIEW
09.02.05

UNDER REVIEW
09.02.05
OK 06.10.22



DETAIL D:
CUFF TRANSITION
SCALE 9:1

RELEASED
06.10.21

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				DATE	06.10.31	TITLE		CROSSTUBE (AS 350/355 HI AFT)		
						SCALE		1:4		